

Work Order ID 77809

Wednesday, December 21, 2011 1:10:11 PM

77809

Soom Page 1

Item ID: D3296-041 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Assembly
Start Date: 12/21/2011 Start Qty: 2.00 *?
Required Date: 12/26/2011 Req'd Qty: 2.00 *?
Reference: Cust Item ID:
Customer:

Approvals: Process Plan: umf Date: 11-12-21 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3296	Rev A

100 0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

120

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

W 115128

3200 F

11:00

EP 11/12/22 (2)

(72)

2X DM 11/12/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77809***77809***

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Wednesday, December 21, 2011 1:10:11 PM

Item ID: D3296-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Door Assembly

Stop ***NS2***

Start Date: 12/21/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/26/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

2

BK 11-12-28

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3296

EP 11/12/28 (2)

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

8 11/12/28

(12)

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 Revision ID: Stop ***NS2***
 Item Name: Door Assembly
 Start Date: 12/21/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/26/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>218</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

11/21/11 [Signature]

CK 12/10/11

*R17-12-29
Q*

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 1

Work Order ID: 77809

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 12/21/2011

Required Date: 12/26/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2137 Decal - No Step		Manufactured	No			140	Each	22.0000	1	2		12/28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		22							
				72053		2							
				76064		20							
D2419 Handle		Manufactured	No			140	Each	6.0000	1	2		12/28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		6							
				76080		6							
D2462 Seal		Manufactured	No			140	f	410.0000	0.3333	0.6666		12/28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST404		410							
				48530		410							
D2728-1 Dart Logo label		Manufactured	No			140	Each	0.0000	0	0			
D3161-7 Hinge 14.0"		Manufactured	No			100	Each	7.0000	1	2		12/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		7							
				76938		7							
D3161-9 Hinge 17.0"		Manufactured	No			100	Each	6.0000	1	2		12/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		6							
				76939		6							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3296-041
Parent Item Name: Door Assembly

Start Date: 12/21/2011 Required Date: 12/26/2011
Start Qty: 2.00 Required Qty: 2.00

D3296-1
Door Panel

Manufactured No

100 Each 18.0000

1 2 *GP 11/12/22*

Location	Loc Qty	Loc Code
ST186	18	
74614	2	
75064	16	

D3296-3
Door Panel

Manufactured No

100 Each 22.0000

1 2 *GP 11/12/22*

Location	Loc Qty	Loc Code
ST186	22	
74615	6	
75061	16	

MS20470AD4-4
Rivet, Universal Head

Purchased No

140 Each 3,928.0000

25 50 *GP 11/12/22*

Location	Loc Qty	Loc Code
ST319	3928	
116188	136	
116391	66	
118614	1190	
119109	2000	
119386	536	

MS20470AD4-6
Rivet, Universal Head

Purchased No

100 Each 2,729.0000

1 2 *GP 11/12/28*

Location	Loc Qty	Loc Code
ST319	2729	
117395	28	
118927	701	
119109	1000	
119546	1000	

NAS1149DN632J
Washer

Purchased No

140 Each 695.0000

1 2 *GP 11/12/28*

Location	Loc Qty	Loc Code
ST298	695	
118428	695	

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Shop Packet Print

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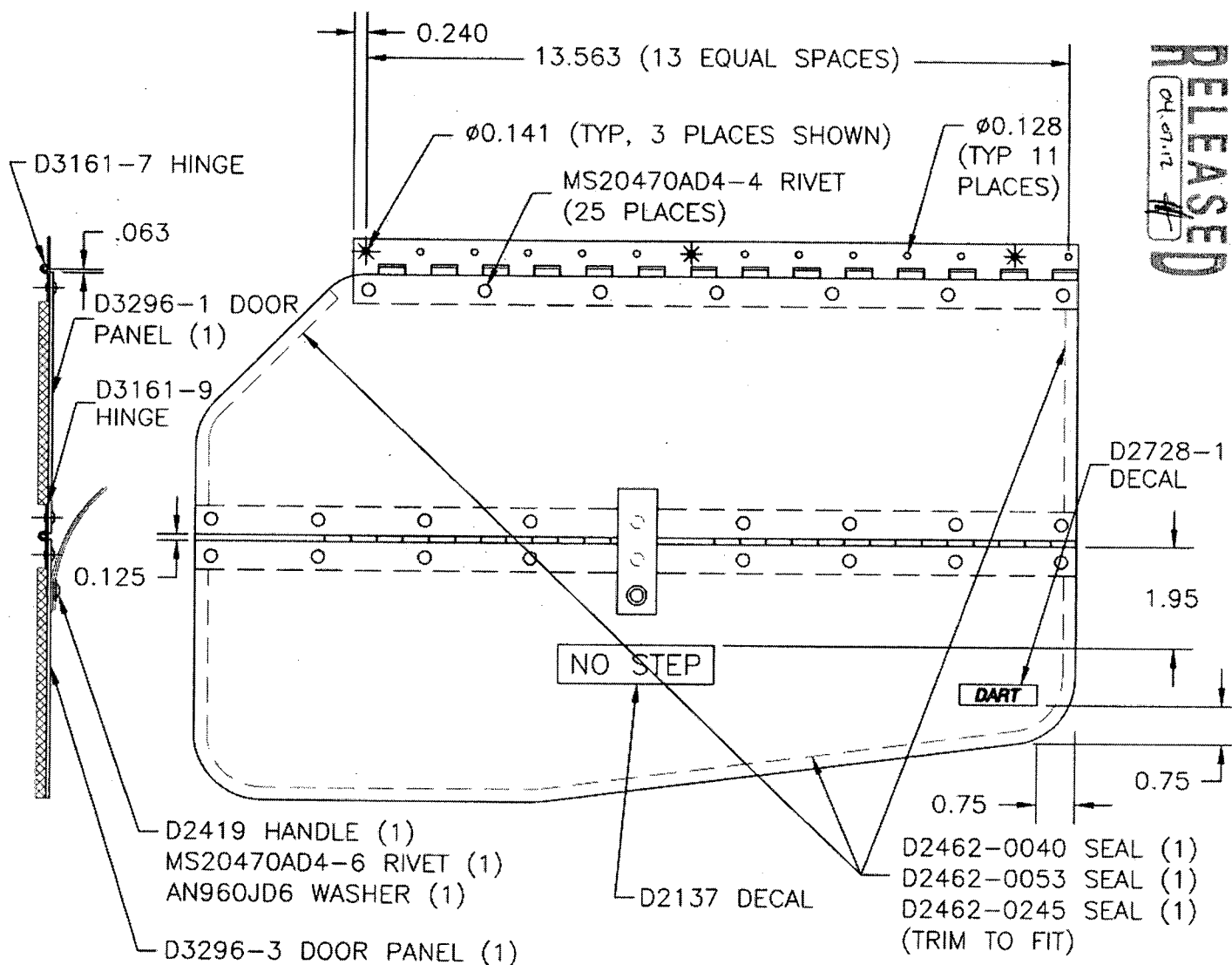
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RELEASED
04.07.12

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. A	
DATE		D3296	1 OF 2	
04.06.28		TITLE	SCALE	
A	04.06.28	DOOR ASSEMBLY	1:3	
		NEW ISSUE		



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

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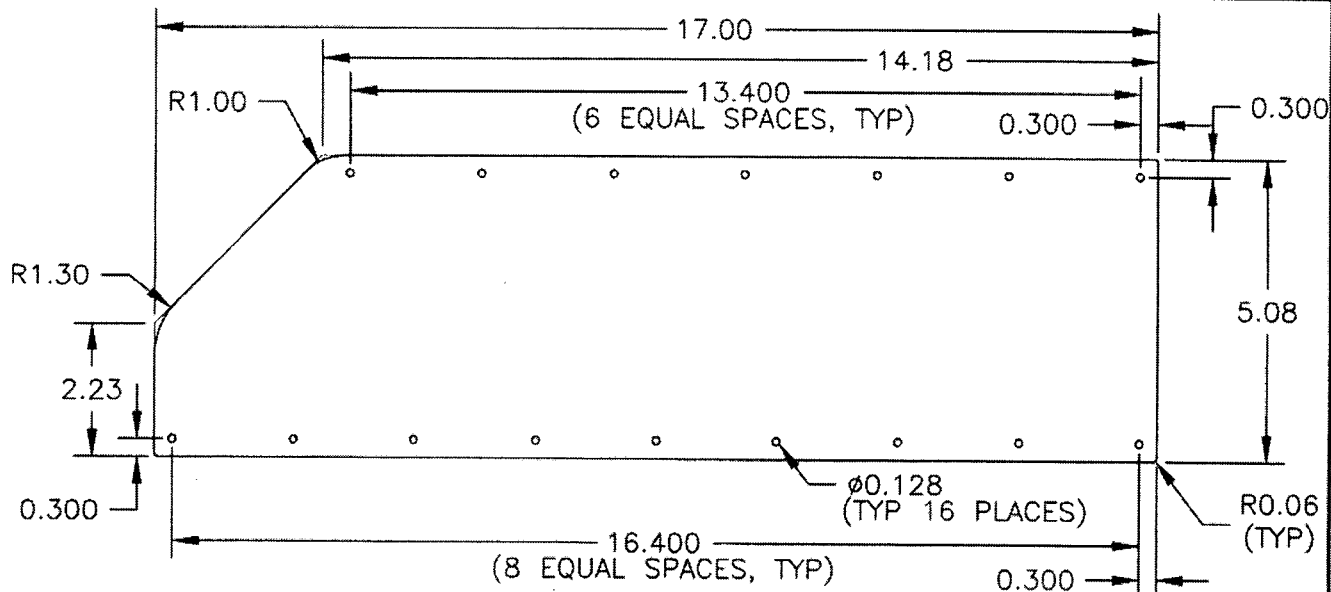
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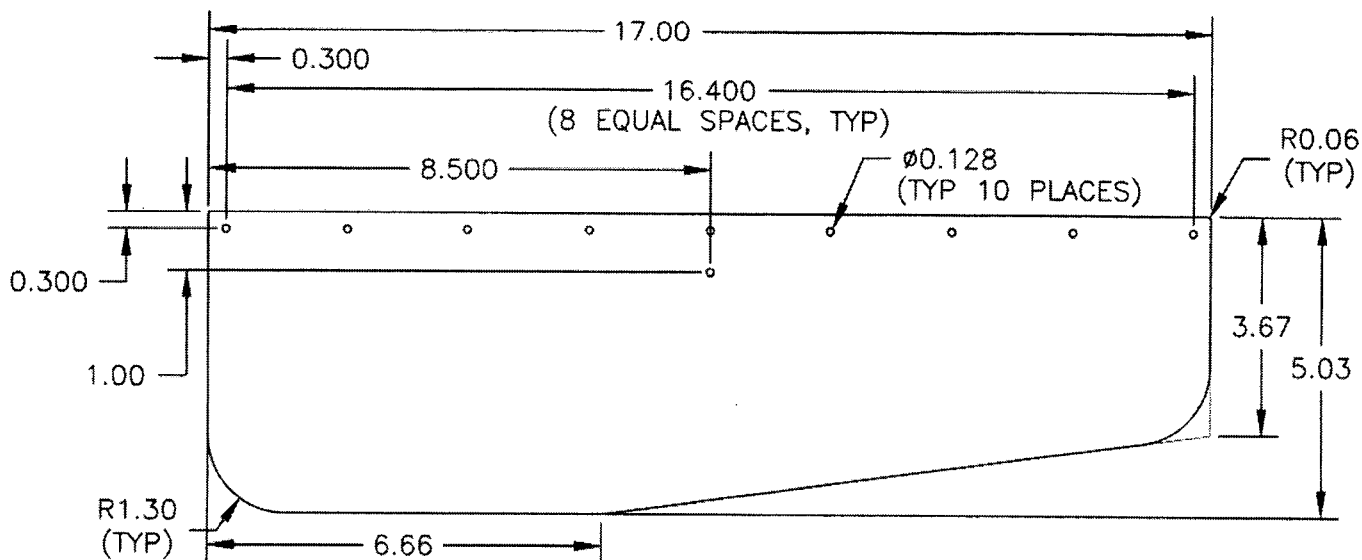
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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04.07.12

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